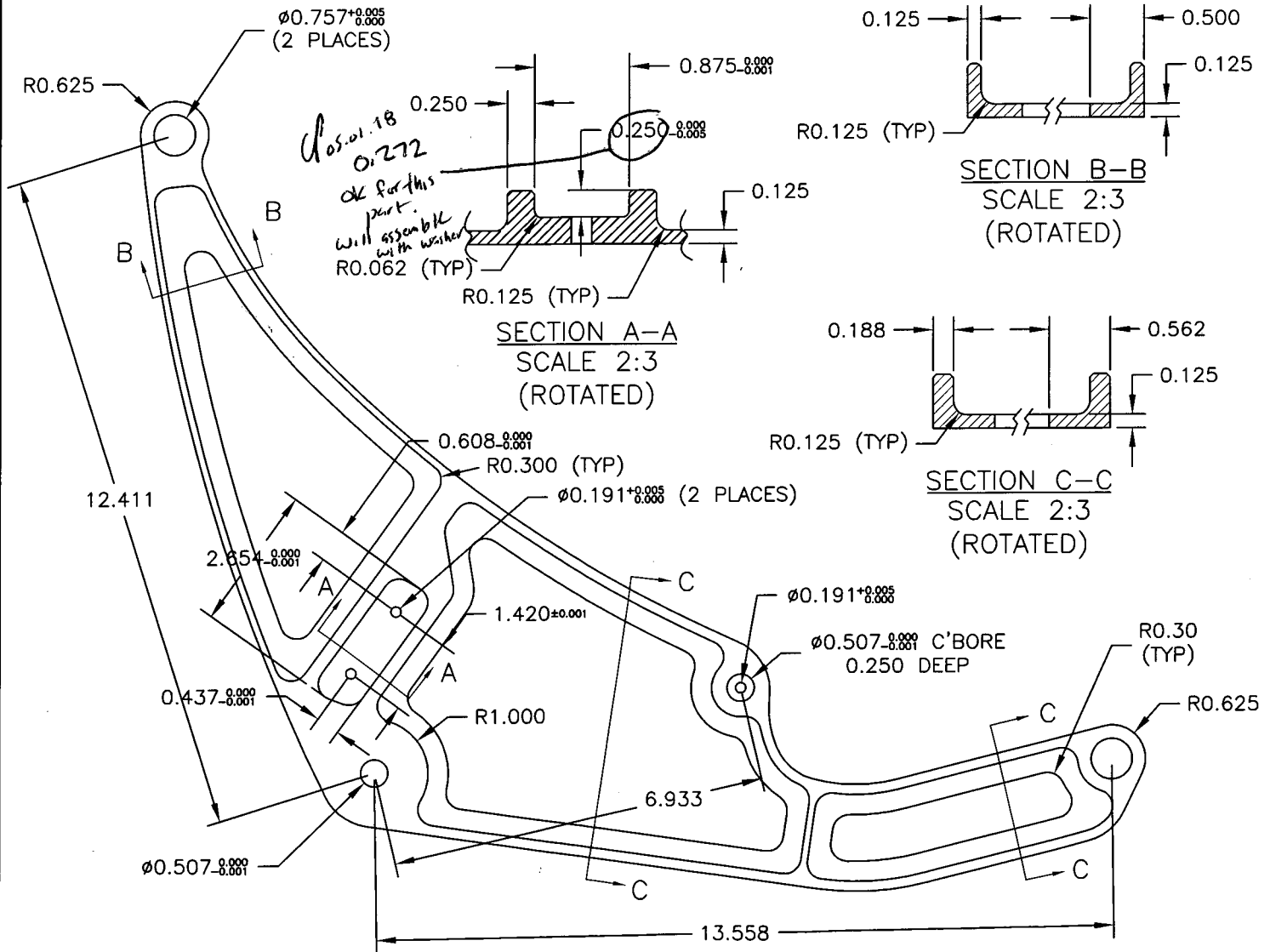


| | | |
|---|--|-----------------------------------|
| DART AEROSPACE LTD | | Work Order: 22269. |
| Description: D2804-1/-2, D2803-1/-2 Re-work. | | Part Number: 22269 141 |
| Dwg: D2803: D2804. Rev B. | | Qty: Page of |

| Step | Location | Procedure | By | Date | Qty | | | | | | | | | | | | | | | | | | | | |
|------|----------|---|-------|----------|------|-------|---|---------|----------------|--|---|---------|----------------|--|---|---------|----------------|--|---|---------|---------------|--|--|--|--|
| 1 | DC | Issue Traveler | JA | 05.01.17 | | | | | | | | | | | | | | | | | | | | | |
| 2 | MV | Pick: | | | | | | | | | | | | | | | | | | | | | | | |
| | | <table border="1"> <thead> <tr> <th>Qty</th> <th>Part #</th> <th>Desc</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D2803-1</td> <td>Bracket B14239</td> <td></td> </tr> <tr> <td>2</td> <td>D2804-1</td> <td>Bracket B14241</td> <td></td> </tr> <tr> <td>1</td> <td>D2803-2</td> <td>Bracket B14240</td> <td></td> </tr> <tr> <td>1</td> <td>D2804-2</td> <td>Bracket B2B05</td> <td></td> </tr> </tbody> </table> | Qty | Part # | Desc | Batch | 2 | D2803-1 | Bracket B14239 | | 2 | D2804-1 | Bracket B14241 | | 1 | D2803-2 | Bracket B14240 | | 1 | D2804-2 | Bracket B2B05 | | | | |
| Qty | Part # | Desc | Batch | | | | | | | | | | | | | | | | | | | | | | |
| 2 | D2803-1 | Bracket B14239 | | | | | | | | | | | | | | | | | | | | | | | |
| 2 | D2804-1 | Bracket B14241 | | | | | | | | | | | | | | | | | | | | | | | |
| 1 | D2803-2 | Bracket B14240 | | | | | | | | | | | | | | | | | | | | | | | |
| 1 | D2804-2 | Bracket B2B05 | | | | | | | | | | | | | | | | | | | | | | | |
| | | ENSURE TO KEEP TRACK OF Batch #'s | | | | | | | | | | | | | | | | | | | | | | | |
| 3 | MV | MACHINE AS PER Rev. B: D2803: D2804 Rev B. | ME | 05/01/18 | | | | | | | | | | | | | | | | | | | | | |
| 4 | QC5 | Inspect Work to Step #3. | JANE | 05/01/18 | | | | | | | | | | | | | | | | | | | | | |
| 5 | FP | Chemical Conversion Coat AS PER DART QSI 005 4.1. | JE | 05-01-18 | | | | | | | | | | | | | | | | | | | | | |
| 6 | QC3 | Inspect Chemical Conversion Coat. | MM | 05.01.19 | | | | | | | | | | | | | | | | | | | | | |
| 7 | ST | Identify & Stock as Rev B. ^{stock only} D2804-1 B14241 | CL | 05/01/27 | 1 | | | | | | | | | | | | | | | | | | | | |
| 8 | AC | Cost/Part 164.48 | SUC | 05-07-28 | | | | | | | | | | | | | | | | | | | | | |
| 9 | DC | Close w/o. | JA | 05.01.31 | | | | | | | | | | | | | | | | | | | | | |

| Rev | Date | Change | Revised By | Approved |
|-----|------|--------|------------|----------|
| 1 | | | | |

| | | | |
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| DESIGN | DRAWN BY | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | APPROVED | DRAWING NO. D2803 | REV. B SHEET 1 OF 2 |
| DATE 04.11.22 | | TITLE STA 84 BRACKET | SCALE 1:3 |
| A | 00.11.07 | NEW ISSUE | |
| B | 04.11.22 | ADD CUTOUTS | |



REFERENCE ONLY

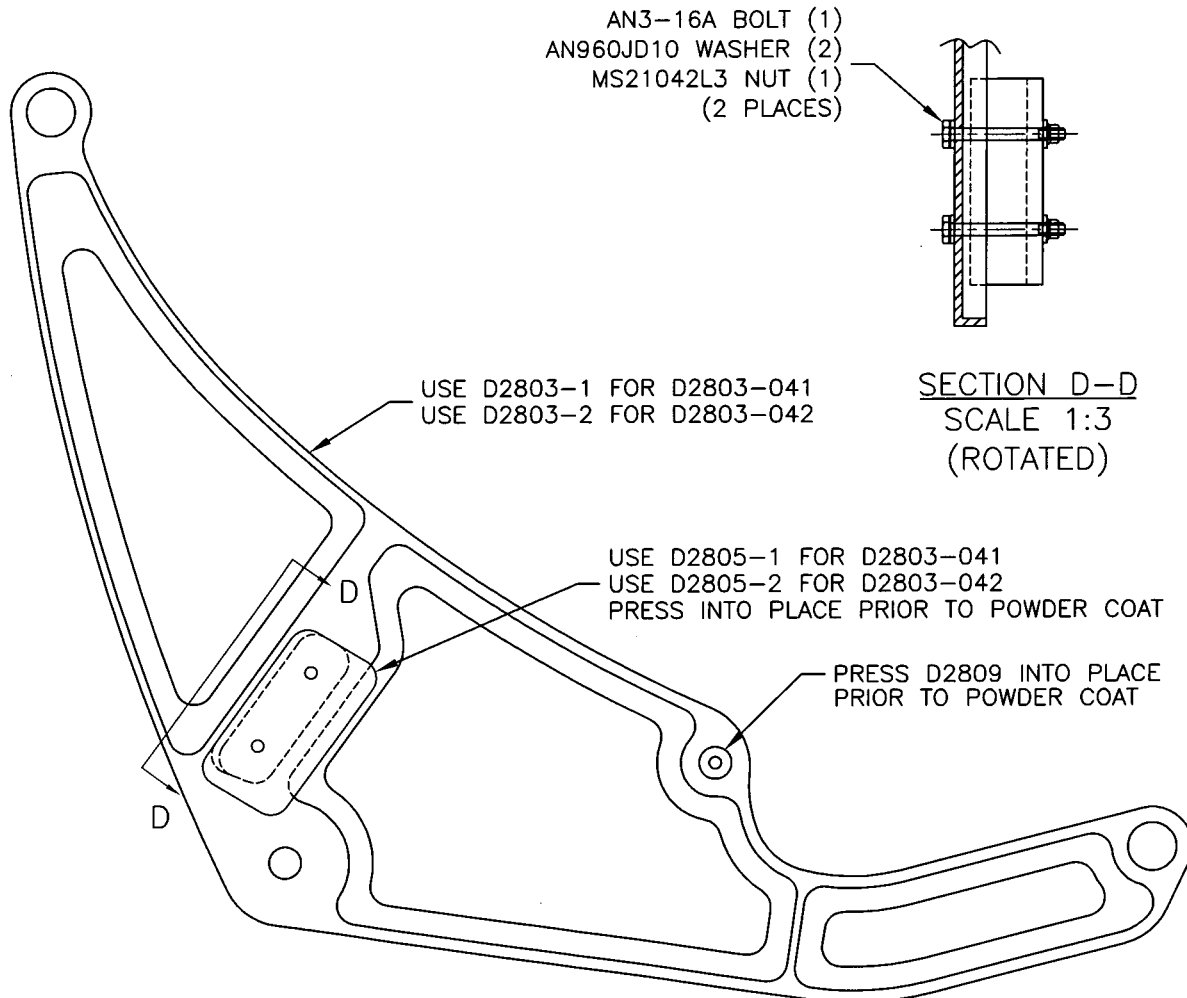
D2803-1 BRACKET (SHOWN). D2803-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2803.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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| CHECKED | APPROVED | DRAWING NO. D2803 | REV. B SHEET 2 OF 2 |
| DATE 04.11.22 | TITLE STA 84 BRACKET | | SCALE 1:3 |



REFERENCE ONLY


D2803-041 BRACKET ASS'Y (SHOWN). D2803-042 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6) OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

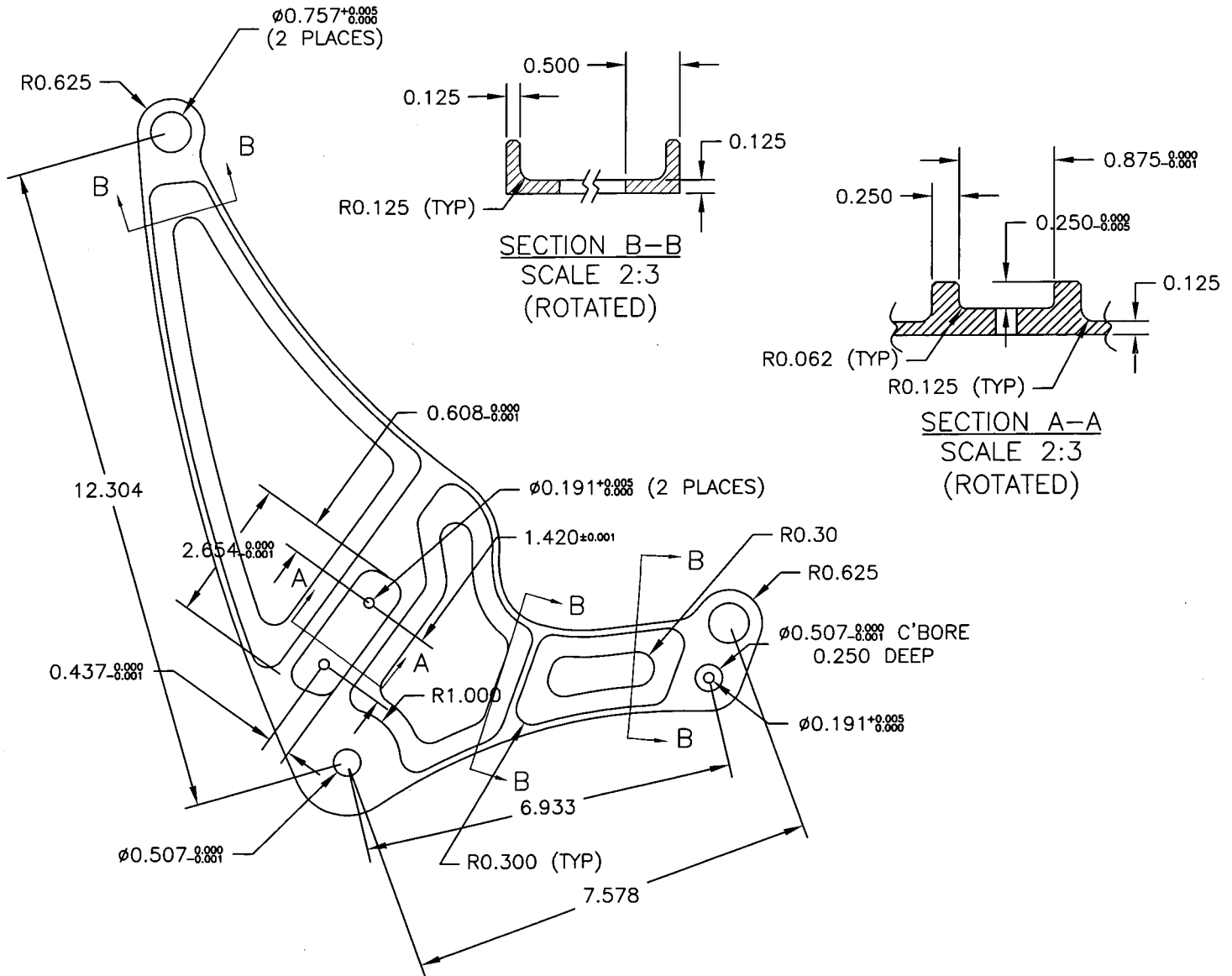
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PRELIMINARY ISSUE

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| CHECKED | | APPROVED | | DRAWING NO. REV. B D2804 SHEET 1 OF 2 | |
| DATE 04.11.22 | | | TITLE SCALE STA 155 BRACKET 1:3 | | |
| A | 00.11.07 | | NEW ISSUE | | |
| B | 04.11.22 | | NEW ISSUE | | |

REFERENCE ONLY



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804.SLDPRT"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
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- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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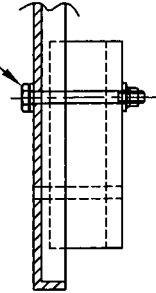
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PRELIMINARY ISSUE

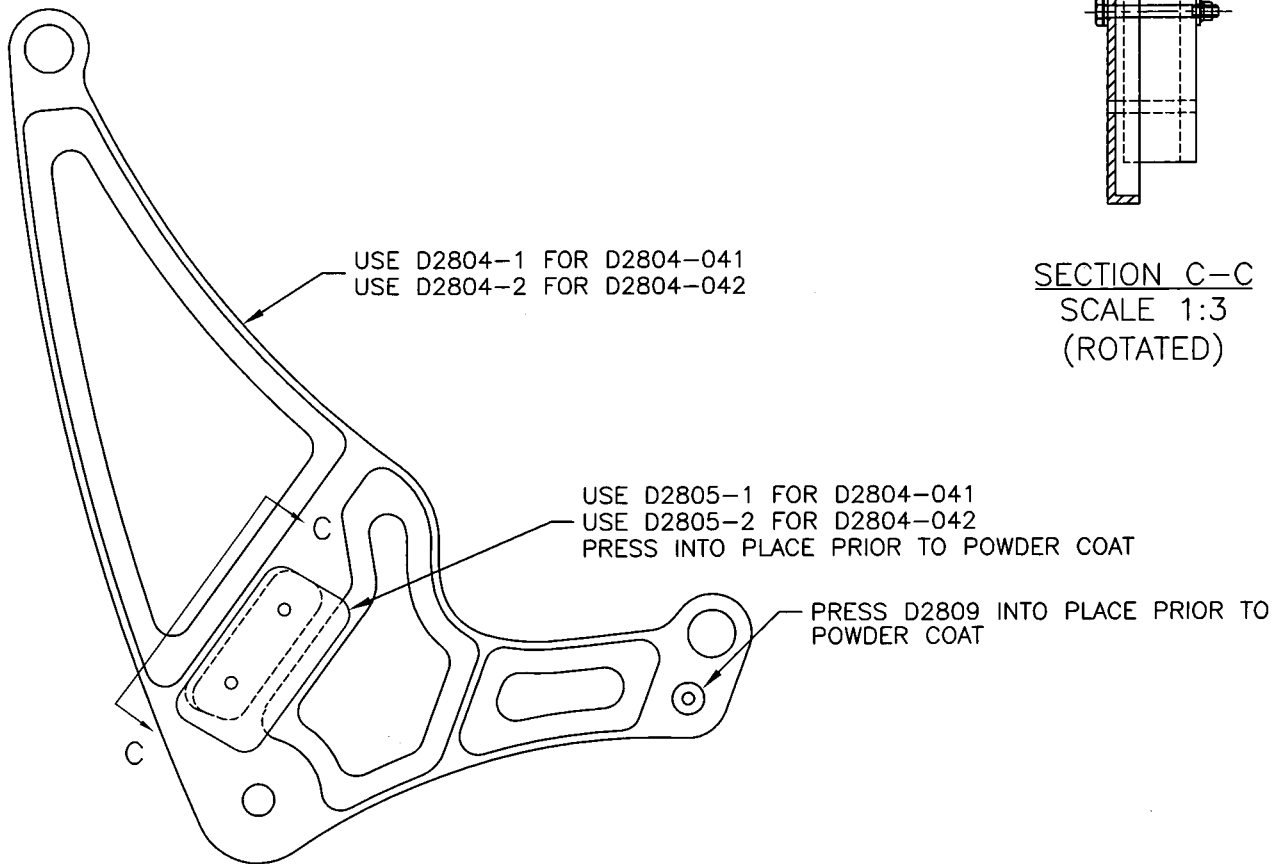
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| CHECKED | APPROVED | DRAWING NO. D2804 | REV. B SHEET 2 OF 2 |
| DATE 04.11.22 | TITLE STA 155 BRACKET | | SCALE 1:3 |

REFERENCE ONLY

AN3-16A BOLT (1)
AN960JD10 WASHER (2)
MS21042L3 NUT (1)
(1 PLACE)



SECTION C-C
SCALE 1:3
(ROTATED)



D2804-041 BRACKET ASS'Y (SHOWN). D2804-042 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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